

Work Order ID 65673

January 21, 2011 1:54:04 PM

Page 1

Item ID: D3914-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Long Basket Lid Assembly (350)

Start Date: 1/21/11 Start Qty: 1.00

Cust Item ID:

Required Date: 2/02/11 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3914

B

100

Weld per dwg A/R S.S. rod Batch: 117585 0.00



Large Fab

Memo

0.00

Large Fab

1- assemble ribs , weld as per dwg D3914 using DT9607A
2- weld hinge (3) and Mounting brackets as per dwg D3914
inspect before welding mesh

3- tack weld mesh on basket as per dwg D3914

make sure to place mesh correctly on lid, check with label plate before tacking mesh

11.02.09
11.02.08

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

① Ø BE 1/02/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65673

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Item ID: D3914-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Lid Assembly (350)

Start Date: 1/21/11 Start Qty: 1.00



Cust Item ID:

Required Date: 2/02/11 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
QC	Memo	0.00							
Quality Control									
130	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
Powdercoat	Memo	0.00							
Powder Coating	*** mask sides of frame prior to powdercoat*** Start Time: 8:40 Oven Temperature: 320° Finish Time: 8:10.								
140	Wing Walk as per dwg QSI005 4.4 Batch 1116042	0.00							
HandFinish	Memo	0.00							
Hand Finishing	1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install placard and label as per dwg								

Accept Qty: 11 Reject Qty: 02 Insp. Stamp: 10 ①

1 BK 11-02-10.

1 7-11 11/02/10

Work Order ID 65673

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Item ID: D3914-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Lid Assembly (350)

Start Date: 1/21/11 Start Qty: 1.00



Cust Item ID:

Required Date: 2/02/11 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

QC3- Insp Part Finish

0.00



QC

Memo

0.00

Quality Control

EP 11/02/11 (P)

160

Identify as per dwg & Stock Location: *C.A*

0.00



Packaging

Memo

0.00

Packaging

w/o 65668

EP 11/02/11 (D)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/11 (J)
MF
11-02-11

Picklist Print

January 21, 2011 1:54:02 PM

Page 1

Work Order ID: 65673

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)



Start Date: 1/21/11

Required Date: 2/02/11

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
as per dwg revB DD 10.08.18 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

✓ D2581

Mounting Bracket

Manufactured No

100

Each

33.0000

2

2



lpl 11.02.09

Location

Loc Qty

Loc Code

WA

33

64112

20

64425

13

②

/ D3914-1

Rib

Manufactured No

100

Each

4.0000

2

2



lpl 11.02.09

Location

Loc Qty

Loc Code

WA

4

65316

4

②

/ D3914-7

Rib

Manufactured No

100

Each

0.0000

2

2



365404 → ② lpl 11.02.09

/ D4016-3

Hinge Half Lid

Manufactured No

100

Each

14.0000

3

3



lpl 11.02.09

Location

Loc Qty

Loc Code

WA

14

64845

8

65425

6

③

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 21, 2011 1:54:02 PM

Work Order ID: 65673

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 1/21/11

Required Date: 2/02/11

Start Qty: 1.00

Required Qty: 1.00

✓ D4018-5

Rib

Manufactured No

100 Each

16.0000 9



Pl 11.02.09

Location

Loc Qty

Loc Code

WA

16

64067

16

✓ D4020-5

Mesh (350 Basket Long, Lid)

Manufactured No

100 Each

2.0000 1



365428 → ⑤
Pl 11.02.09

Location

Loc Qty

Loc Code

WA

2

60643

1

64847

1

✓ D4021-3

Data Plate

Manufactured No

100 Each

3.0000 1



Pl 11.02.09

Location

Loc Qty

Loc Code

WA

3

56050

1

64924

2

✓ D4035-041

Lid Rib Assembly, Fwd (350 Basket)

Manufactured No

100 Each

1.0000 1



365916 → ①
Pl 11.02.09

Location

Loc Qty

Loc Code

WA

1

64849

1

365426 → ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 21, 2011 1:54:03 PM

Page 3

Work Order ID: 65673

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 1/21/11

Required Date: 2/02/11

Start Qty: 1.00

Required Qty: 1.00

D4035-043

Manufactured No

100

Each

1.0000

1

1



Lid Rib Assembly, Aft (350 Basket)



PL 11.02.09

Location

Loc Qty

Loc Code

WA

1

64850

1

D2728-3

Manufactured No

140

Each

0.0000

1

1



Dart Logo label

115050



365427 → ①

(x1) M 11/02/10

January 21, 2011 1:54:03 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

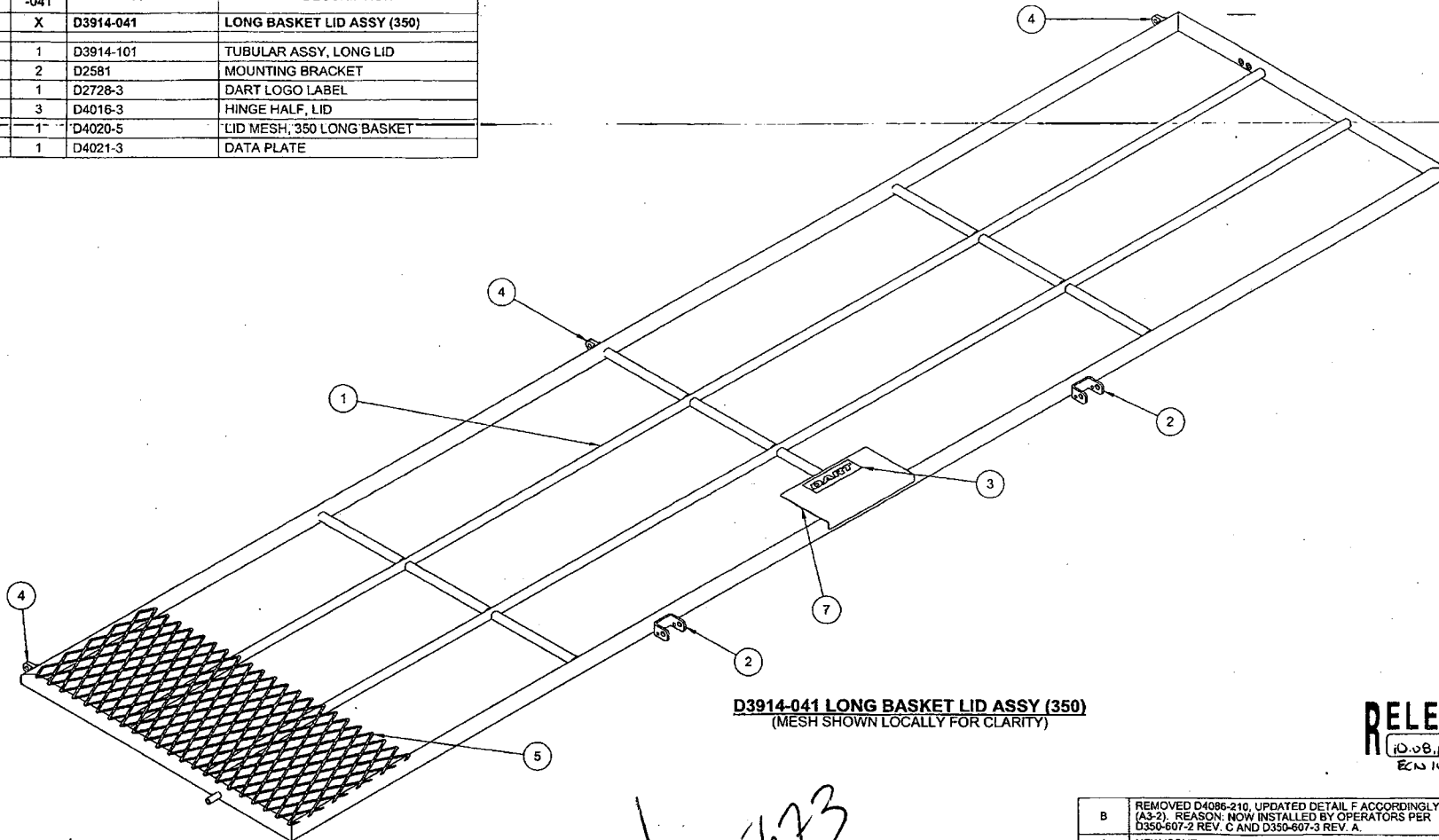
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE

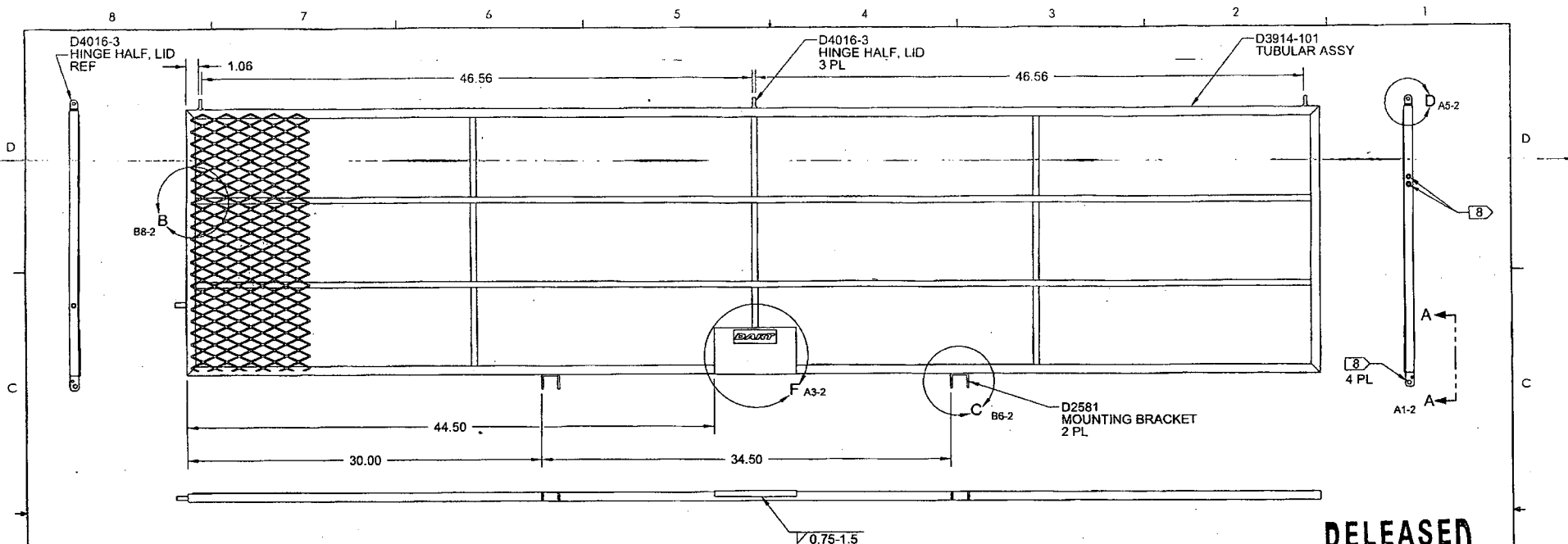


D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10-08-17
ECN 10-596

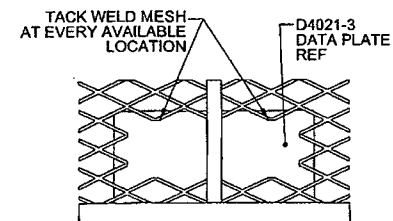
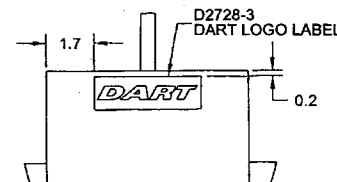
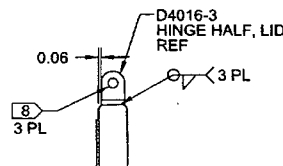
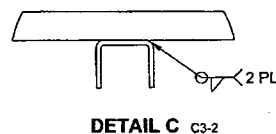
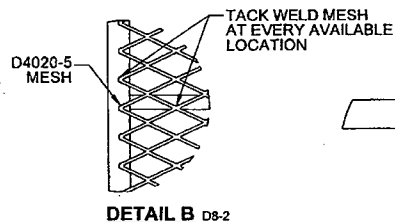
B	REMOVED D4086-210, UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC	DRAWING NO.	REV. B
CHECKED	SC	D3914	SHEET 1 OF 4
MFG. APPR.	AS	TITLE	SCALE
APPROVED	AS	LONG BASKET LID ASSY (350)	NTS
DE APPR.	AS	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
DATE	10.03.05	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/065673



RELEASED
10.08.05

D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.35 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004

65673

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	3	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO. D3914	REV. B
MFG. APPR.	WJ	SHEET 2 OF 4	
APPROVED	WJ	SCALE	
DE APPR.	WJ	LONG BASKET LID ASSY (350) NTS	
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE INFORMATION AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT

0.25

SECTION E-E C5-3

D4035-041
RIB ASSY, FWD

TYP

E C2-3

TYP

D4035-043
RIB ASSY, AFT

22.50

6.67
TYP

TYP

D3914-1
RIB
2 PL

D4018-5
RIB
9 PL

D3914-7
RIB
2 PL

23.25
TYP

8 D3914-101 TUBULAR ASSY, LONG LID

RELEASED
10-08-12

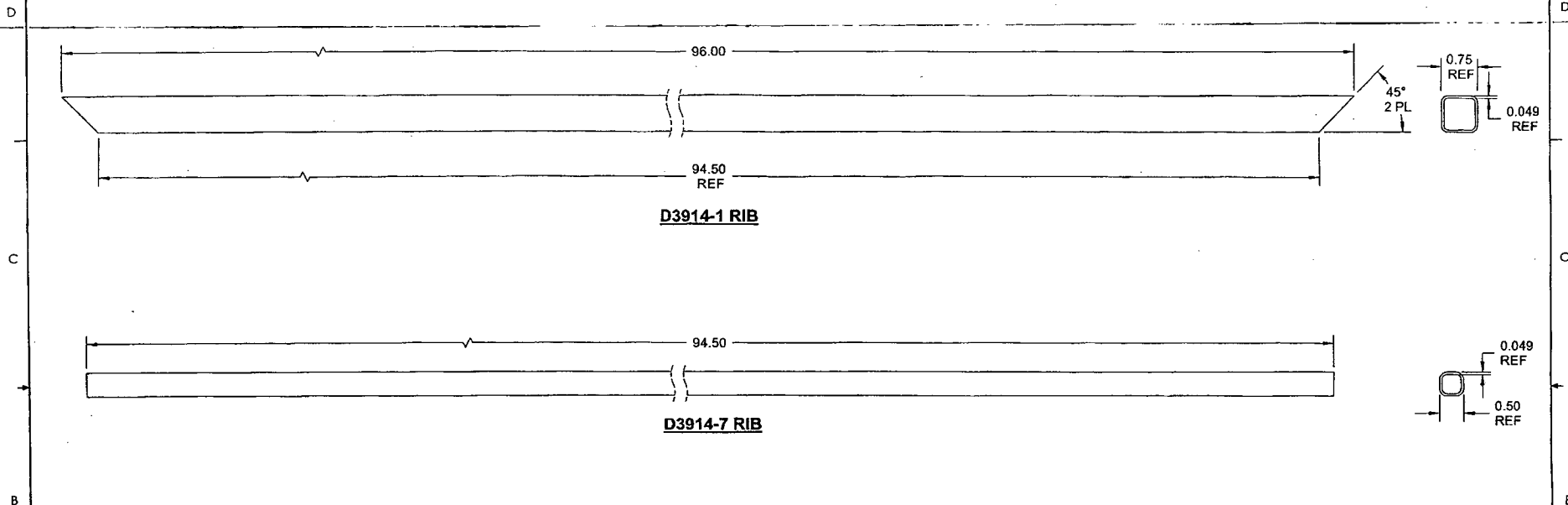
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.10 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
- 9) WELD PER DART WSP004

65673

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	TC	DRAWING NO.	REV. B
MFG. APPR.		D3914	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET LID ASSY (350)	NTS
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1



D3914-1 RIB

D3914-7 RIB

NOTES:

1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-7: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

65673

RELEASED
10.08.12 QP

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	B	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. B
MFG. APPR.	AK	D3914	SHEET 4 OF 4
APPROVED	WD	TITLE	SCALE
DE APPR.	TH	LONG BASKET LID ASSY (350)	NTS
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8 7 6 5 4 3 2 1